

Work Order ID 65703

January 24, 2011 8:47:00 AM

Page 1

Item ID: D3405-043

Revision ID:

Item Name: Lug Assembly

Start Date: 1/24/11 Start Qty: 15.00

Required Date: 2/11/11 Req'd Qty: 15.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3405	Rev B

100 0.00



Waterjet
FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3405
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

0.00

B11-1-04

110 0.00



QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B11-1-04

120 0.00



QC
Quality Control

QC8- Inspect parts - second check

Memo

0.00

8/15/12

415

2

DRAW GREEN

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65703

January 24, 2011 8:47:01 AM



Page 2

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 1/24/11 Start Qty: 15.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo 1-Debur 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming	0.00 0.00				(15)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SB 11/01/26					
150 Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: M107057 Large Fab Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-043	0.00 0.00		EL 11-3-8				X 15	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65703

January 24, 2011 8:47:01 AM



Page 3

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 1/24/11 Start Qty: 15.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00							<i>pl 11-03-09</i>
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							<i>Sulos/09</i> 415
180 	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo	0.00							<i>11-02-17 Drab green (Re: 4.3.5.11) per QSI005</i> <i>15 BR 11-3-9.</i>
	START TIME: <i>2:00</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>2:30</i>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65703

Page 4

January 24, 2011 8:47:02 AM

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 1/24/11 Start Qty: 15.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

15 of 15 1/23/09

200

Identify as per dwg & Stock Location: 423

0.00



Packaging

Memo

0.00

Packaging

64/3/10 (15)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/10

11-03-10
15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 24, 2011 8:47:00 AM

Page 1

Work Order ID: 65703

Parent Item: D3405-043

Parent Item Name: Lug Assembly



Start Date: 1/24/11

Required Date: 2/11/11

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP A1705.09.0111 New issue KJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1 		Manufactured	No			100	Each	0.0000	1	15			
GHW Lug M304S11GA 		Purchased	No		3404 B 65701	X15		70.4003	0.154	2.431579		11-3-8	
304/316 0.125 Sheet												11-1-09	

Location

Loc Qty

Loc Code

MAT

70.4003

114799

0.5003

116437

5.9

116623

64

116437

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

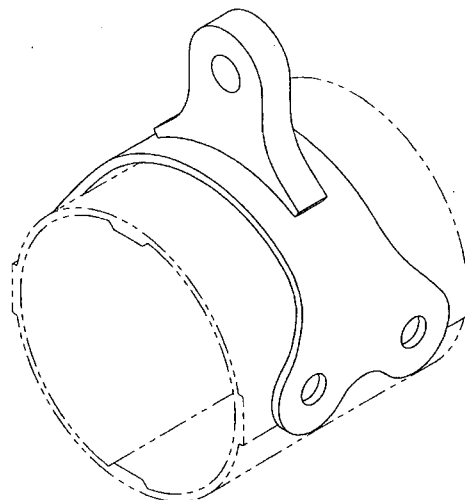
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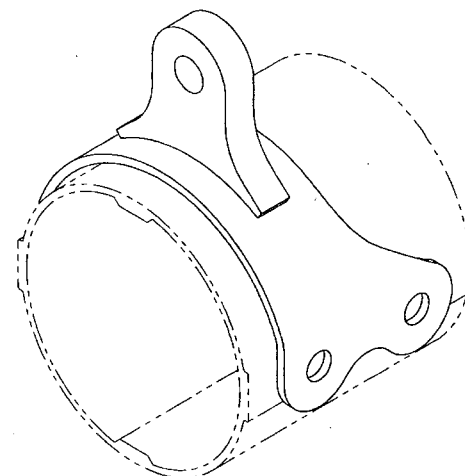
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

u/o 65703

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

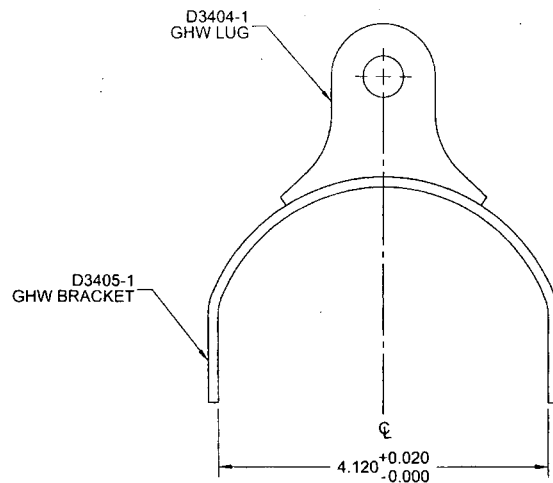
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

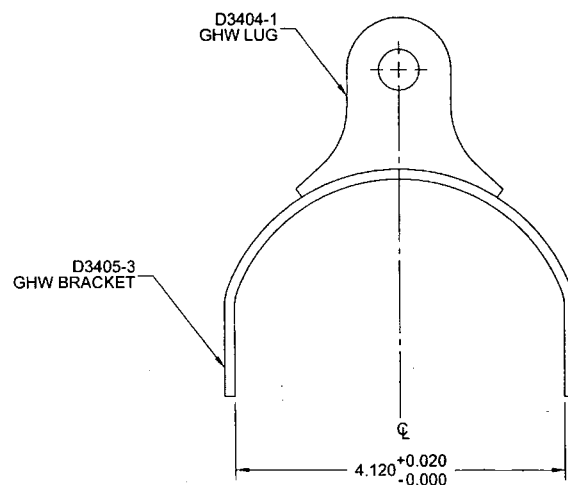
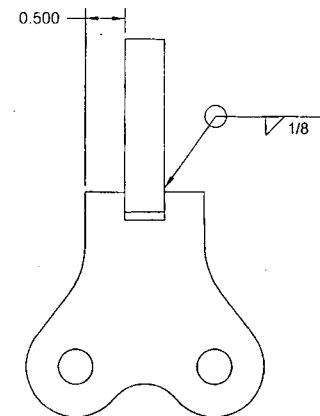
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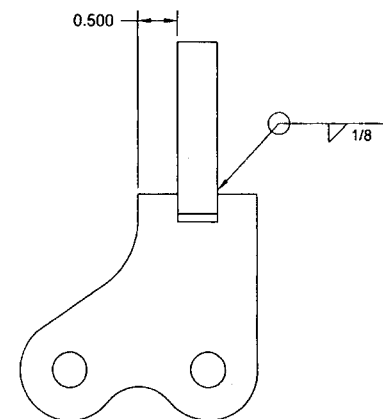
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D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18

65203

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.		TITLE GHW LUG ASSEMBLY	SHEET 2 OF 4
APPROVED		SCALE	NTS
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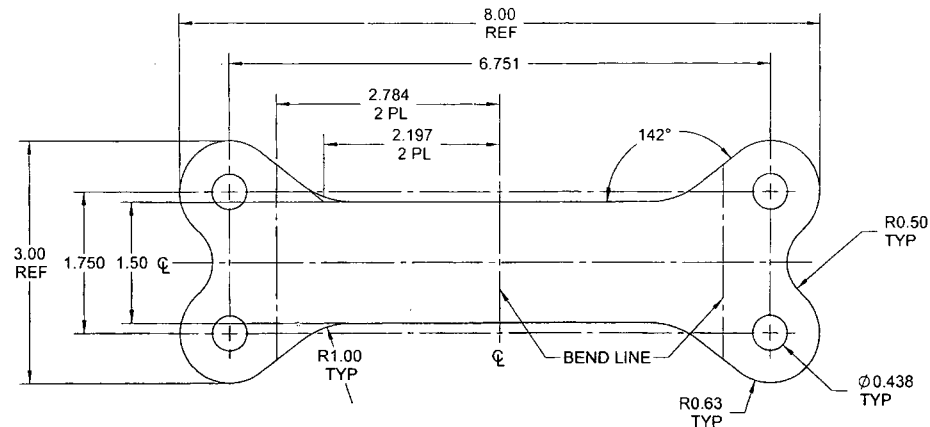
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

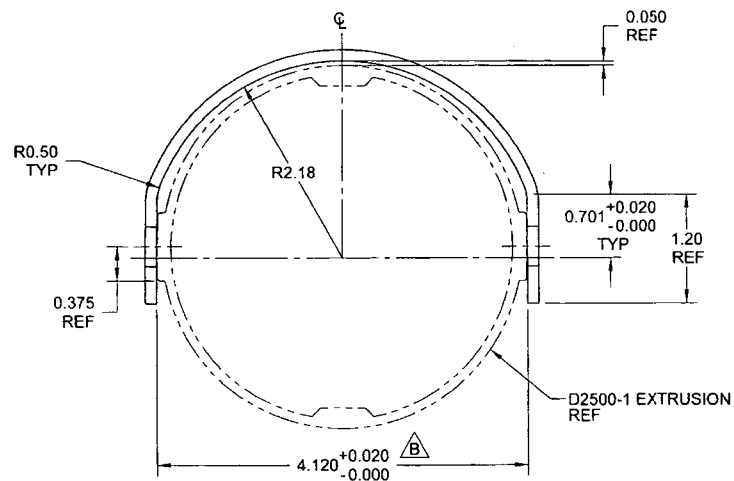
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

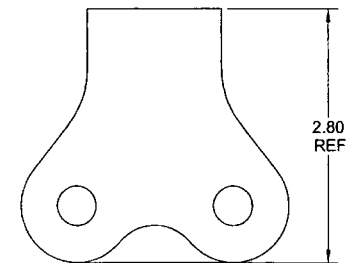
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

65703

RELEASED
08/09/19

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE GHW LUG ASSEMBLY	SCALE NTS
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DATE	08.09.19		

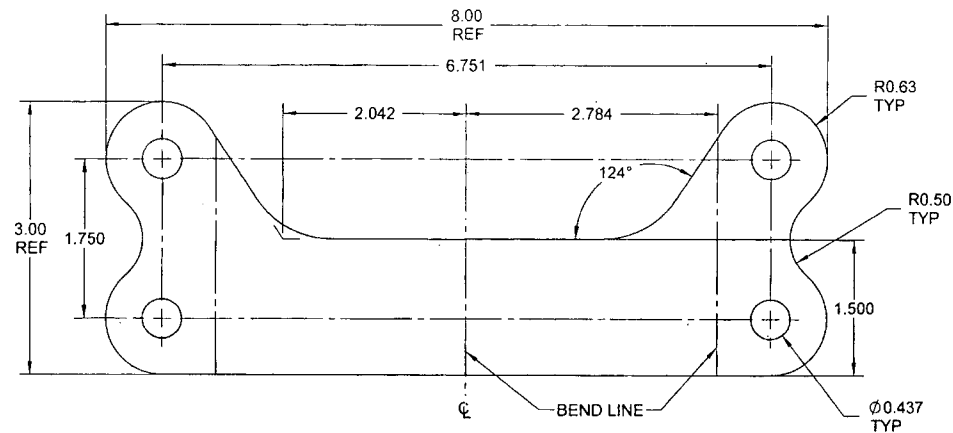
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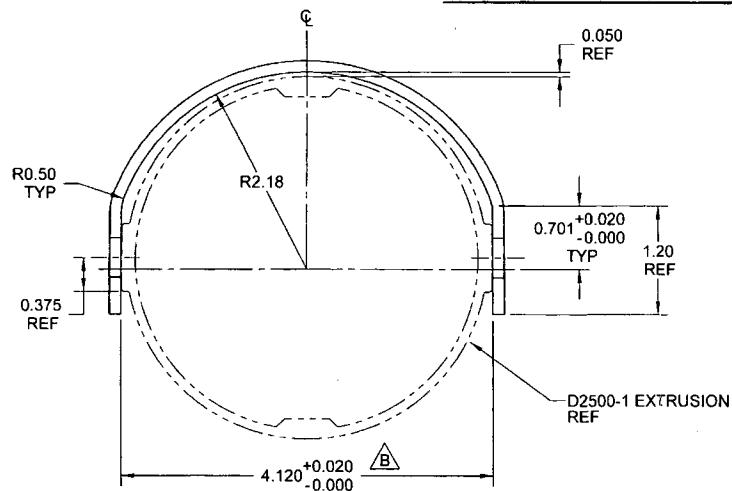
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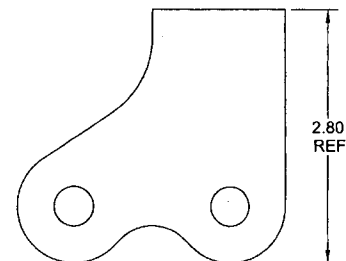
NOTE: Date & initial all entries



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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